

Work Order ID 55214

January 12, 2010 12:31:17 PM

Page 1

Item ID: D2622-120C

Accept



Setup Start



Revision ID:

Item Name: Step Extrusion

Stop



Start Date: 1/12/10

Start Qty: 110.00



Cust Item ID:

Required Date: 1/26/10

Req'd Qty: 110.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2622

Rev C1

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 11107 a) Extrude as per Dwg D2622 Rev. C1 b)
Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35
ksi d) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation =
8% f) Order at 120" longg) Bon L Canada Inc.

u 10.01.12

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure material certification is attached

1/14/2/10 123

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Check Pull test per Dwg D2622 for compliance page attached Check hardness
with Webster tester

Extruded

counter
HTB

could not see any Defs

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January 12, 2010 12:31:17 PM



Page 2

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Start Date: 1/12/10 Start Qty: 110.00



Cust Item ID:

Required Date: 1/26/10 Req'd Qty: 110.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

10-02-16

123

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/16

MF

10-246

Picklist Print

January 12, 2010 12:31:16 PM

Page 1

Work Order ID: 55214

Parent Item: D2622-120C

Parent Item Name: Step Extrusion


Comments:

Start Date: 1/12/10

Required Date: 1/26/10

Start Qty: 110.00

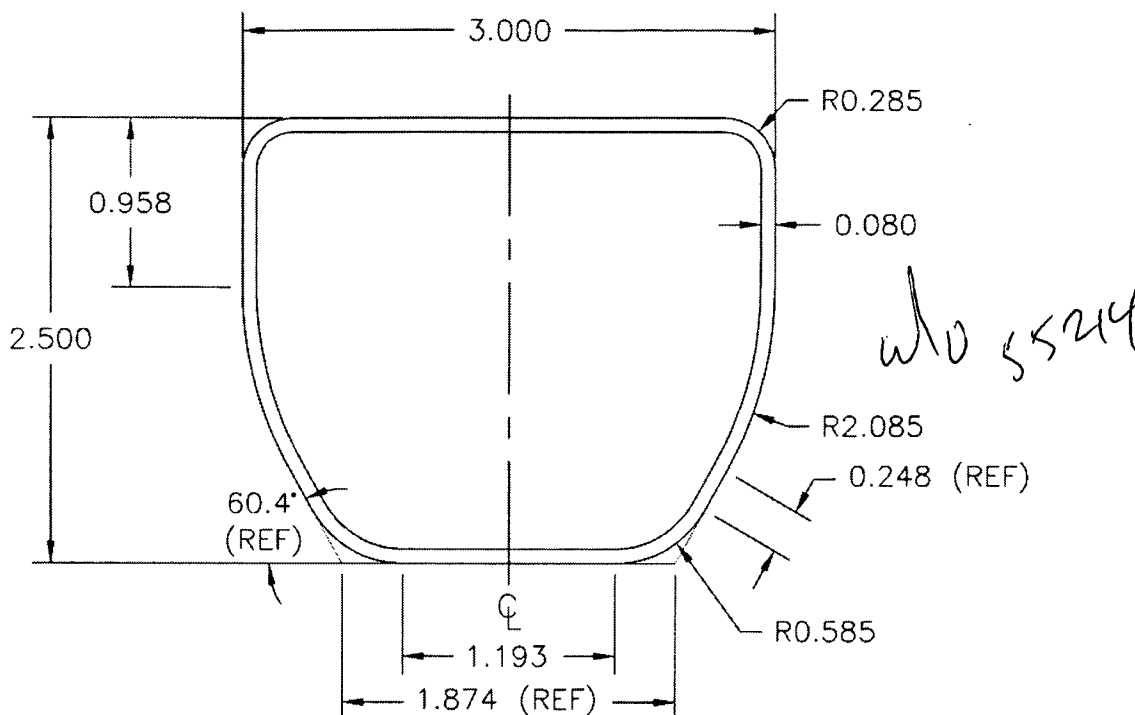
Required Qty: 110.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2622-120CP		Purchased	No			110	Each	0.0000	110.0000			
												
Extrusion												

Pick 1/12/10 (123)



DESIGN KE	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11		TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29	NEW ISSUE	
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.	
C1	02.10.11	ADD 'REV. A' TO DIE NUMBER	



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO11107

Purchase Order Date 1/12/10

PO Print Date 1/13/10

Page Number 1 of 1

Order From :

VC-BON001

SIGNATURE ALUMINUM
1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8
CA

Contact Name
Vendor Phone 800 563 1079
Vendor Fax 800 565 8339
Vendor Account Nbr

Buyer Linda Lacelle
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2622-120CP	Extrusion	2/05/10 Yes	121.00 Each	Yours ppd	\$23.7570	\$2,874.60

Special Inst: EXTRUSE AS PER DRWG D2622
REV C1
MATERIAL: 6061-T6(QQ-A-200/8)
MINIMUM YIELD TENSILE
STRENGTH = 35KSI
MINIMUM ULTIMATE TENSILE
STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%
12" LONG
BON L TOOL # 897123

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

REC 123
1/14/10

PO Total: \$2,874.60

Change Nbr: 2

Change Date: 1/13/10

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

SHIPPING MANIFEST

MANIFEST DATE	02-09-10
MANIFEST NUMBER	676141
SALES ORDER NUMBER	60435

ACCT# 00046024

SHIP TO DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200	SOLD TO / PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200
--	--

TERMS / FREIGHT
O / P

REFER TO THESE NUMBERS ON ALL CORRESPONDENCE
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CREDIT REP HAMBROOK, PAU 905-508-3250	SALES REP
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LOCATION PIC	TRAILER NUMBER RBL	SALESMAN 59358	FIELD SALES REP Kutter A 450-435-6551	CUST SERVICE REP Burton D 905-427-2227
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CUSTOMER ID 46024	ORDER DATE 01/12/10	CUSTOMER PO NUMBER 11107	JOB	BILL OF LADING NUMBER 08404876
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ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION	THIS SHIPMENT			UNIT	QUANTITY DUE
				CUSTOMER PART NUMBER	LENGTH	FABRICATION DESCRIPTION	NBR OF PKGS	GROSS POUNDS	NET QUANTITY		
					CUTTING TOLERANCE	SHIPPING TOLERANCE					
01	121	KG M PC	0 0 0	DAA-897123-1 D2622 							

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives. No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE 1

DATE OF DELIVERY

DRIVER

CUSTOMER ACKNOWLEDGMENT OF GOODS DELIVERED AND CONDITION

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Cert Date	Cert No	Sales Order	Page
02/09/10	203859	60435	1
Cust PO	B/L No	Lot	Date
11107	08404876	60435010	2/09/10
Sold To 46024		Ship To 46024	
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7		DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	

Item No	Part No	Item Description	Cust Part
1.000	DAA-897123-1	120" Mill 6061 T6	D2622
Gross Weight	543 KGS		
Net Qty	515 KG	123 PC	375 M 3 PKG
Specification		Die Desc	
AMS-QQ-A-200/8 & ASTM B221-08			

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	283.4 / 41.1	257.6 / 37.4	11.0	.0	92

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI
.63	.23	.28	.03	.94	.07	.14	.01

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Ryan Petersen, QA Manager Signature Aluminum Canada Inc

8/10/2014

HL